

5/30

DART AEROSPACE LTD		Work Order:	23770
Description: Pin Assembly		Part Number:	D3332-041
Dwg: D3332 Rev. A1		Qty:	20
PAGE 1, 3, 4 05.07.06		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty												
1	DC	Issue Traveler	RJ	05.07.06	20												
2	MC	Machine D3332-3 as per Folio FA493 and Dwg D3332 Material: AISI 1018-1025 Ø0.500" Round Bar (M1018-R0.500) Identify for D3332-3 Batch: <u>M16634</u>	BG	05.07.15	20												
3	QC2	Inspect parts as they come off the CNC machine Identify as D3332-3	BG	05.07.15	20												
4	QC8	Second check	EN	05/07/15	20												
5	MFA	Fabricate D3332-5 as per Dwg D3332 Material: AISI 1018-1025 Ø0.313" Round Bar (M1018-R0.313) Identify as D3332-5 Batch: <u>M16634</u>	CPL	05.07.20	20												
6	MFA	Assemble and Weld using D3332-041T1 as per Dwg D3332 Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3332-1</td><td>Handle</td><td>323054 B23775</td></tr><tr><td>A/R</td><td>N/A</td><td>Steel Rod</td><td>M9326</td></tr></table> Identify as D3332-041	Qty	Part Number	Description	Batch	1	D3332-1	Handle	323054 B23775	A/R	N/A	Steel Rod	M9326	CPL	05.07.20	20
Qty	Part Number	Description	Batch														
1	D3332-1	Handle	323054 B23775														
A/R	N/A	Steel Rod	M9326														
7	QC5	Inspect work to Step 6	2	05.07.20	20												
8	FP	Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005.4.3 Cover D3332-3 and cover thread only for D3332-5 prior to painting	M	05.08.11	20												
9	QC3	Inspect Powder Coat	2	05.08.15	20												
10	ST	Identify and Stock	CPL	05/08/16	20												
11	AC	Cost / part: <u>16.27</u>	54C	05.08.17	20												
12	DC	Close W/O <u>17.99</u> Inspect Level 21	2	05/08/17	20												

Rev	Date	Change	Revised By	Approved
A	05.01.13	New issue	KJ/JLM	

RELEASED
14/05/01.1548 1/2
8 3/4" stop

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

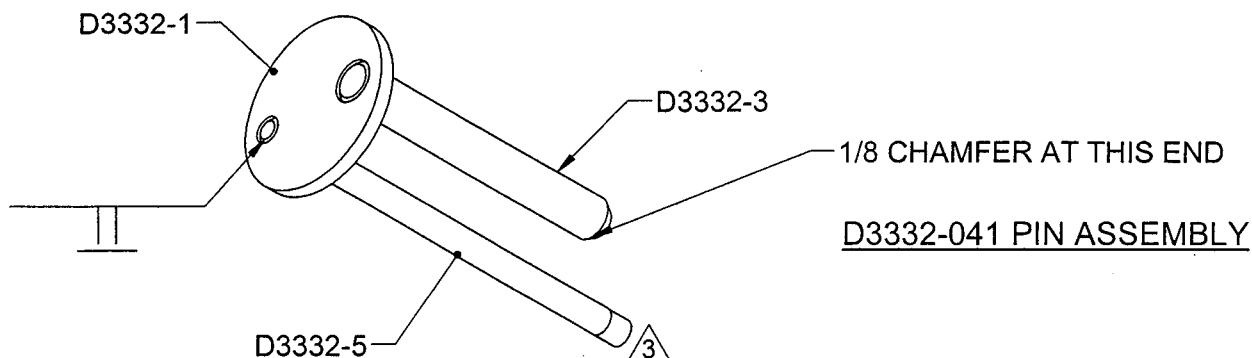
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ED Date: 05/08/07

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

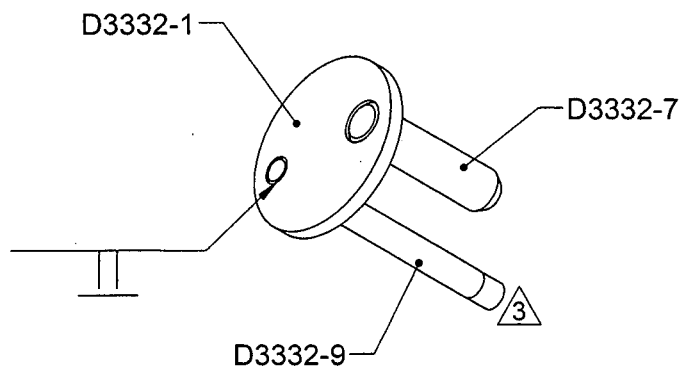


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3332	REV. A SHEET 1 OF 4
DATE 04.12.14		TITLE PIN ASSEMBLY	SCALE 1:2
A	04.12.14	NEW ISSUE	
A1	<i>[Signature]</i> 05.07.04	0.080 WAS 0.050; ADD TOLERANCE +0.000 -0.005	



D3332-041 PIN ASSEMBLY

RELEASED
[Signature]
05/02/09



D3332-043 PIN ASSEMBLY

NOTES:

- 1) POSITION PARTS USING D3332-041T1
- 2) WELD PER DART QSI 004
- 3) MASK THREADS PRIOR PAINTING
- 4) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER QSI 005 4.3.5.10 (COVER THREAD ONLY FOR D3332-5/-9 PRIOR PAINTING)
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.10

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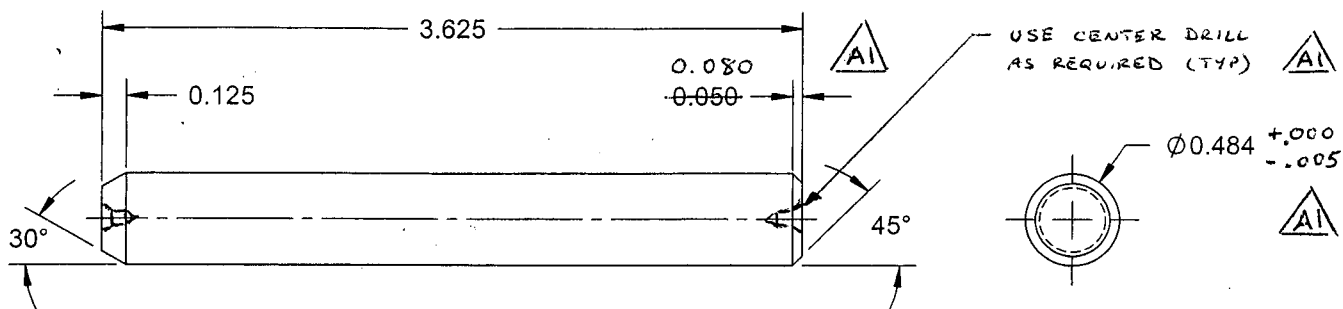
WORK ORDER
NO. 23770

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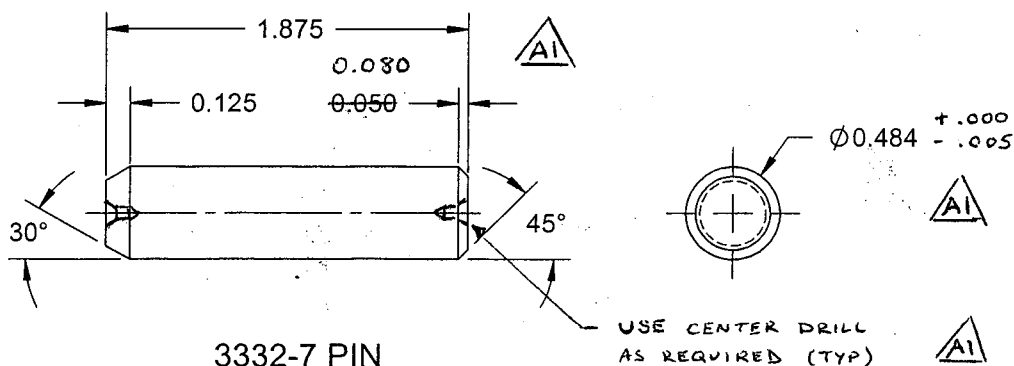


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3332	REV. A SHEET 3 OF 4
DATE 04.12.14		TITLE PIN ASSEMBLY	SCALE 1:1



3332-3 PIN

RELEASED
[Signature]
05/02/09



3332-7 PIN

USE CENTER DRILL
AS REQUIRED (TYP)

NOTES:

- 1) MATERIAL: 1018-1025 ROUND BAR STEEL PER MIL-S-7097 (REF. DART SPEC. M1018R0.500)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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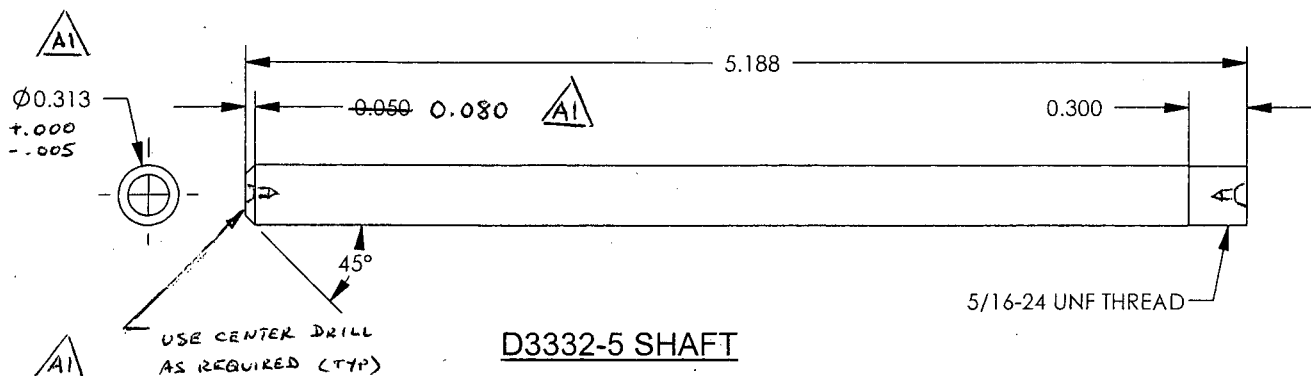
23770

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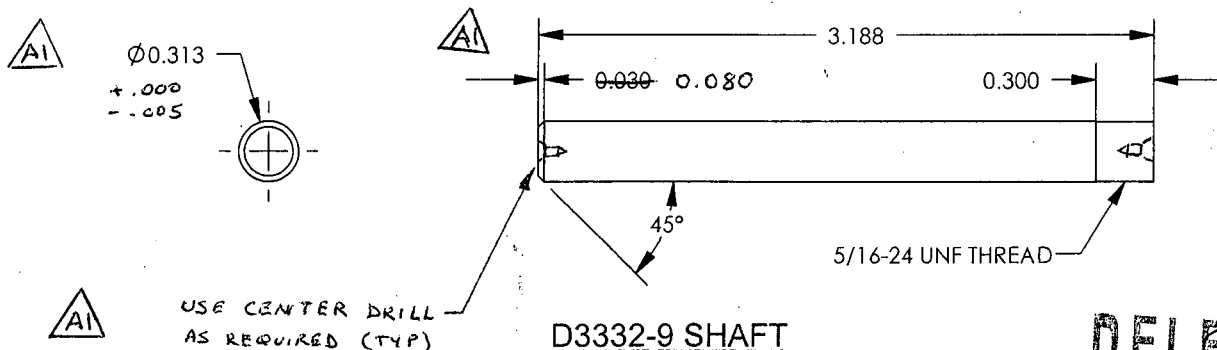
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DESIGN A3	DRAWN BY A3	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED A	APPROVED A	DRAWING NO. D3332	REV. A SHEET 4 OF 4
DATE 04.12.14		TITLE PIN ASSEMBLY	SCALE 1:1



D3332-5 SHAFT



D3332-9 SHAFT

RELEASED
05/02/09

NOTES:

- 1) MATERIAL: 1018-1025 ROUND BAR STEEL PER MIL-S-7097 (REF. DART SPEC. M1018-R0.313)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES

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NOTICE

WORK ORDER
NO. 23770

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jul 06, 2005
11:42 am

Work Order No : 0023770
Project Name : D3332-041
Project For : WK530
Work Order Type : Main
Main WO Number :
House Part Number : D3332-041
Description : Pin Assembly
Manufactured : Yes
Amount Req'd : 20
Amount Done : 0
Start Date : 07-06-05
Est Finish Date : 07-30-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00